

# Work Order ID 56459

February 24, 2010 10:39:53 AM



Page 1

Item ID: D350-600-242

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod, RH, AS350/355

Start Date: 24/02/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 24/03/2010 Req'd Qty: 1.00



Customer:

Reference: Return 2009 / RA109114

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: 7 Date: 10-02-24 SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D350-600	Rev C

100	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------



QC

Memo

Quality Control

Original B48152 @ CHG001.  
Pod has cut out from installing the D350-600-449 kit. Majority of the hardware is used & drilled.

110		0.00
-----	--	------



Eng

Memo

Engineering

Perform a trial fit of the pod onto the AS 350 aircraft using the existing hardware.

\*\*Jason M would like to see the install.\*\*

Attach the Trial Install report.




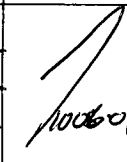
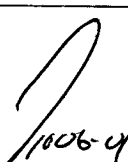
See Jason M to complete the w/o procedures once the install & inspection is complete.

1002-24

100303

<b>DART</b> Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D350-600-242	CHG	CHG001		
DESC.	Spacepod RH	STC	SH93-88		
LOT	B48152	STC	SR00098NY		
MODEL	AS350/355	STC	SR00099NY		
MADE IN CANADA				D2729-1	

# Dart Aerospace Ltd

WFO: 5-6459		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-05-26	110	repair cut out in spacepod due to installation of D350-600-449 kit as per Dart QSE 037 section 9.1 Hole repair in composite skin. 9oz cloth F6778150550 Rol B 11166 epoxyst 50-A1 B 112935		10-05-28				
		QC5	S	10/05/05	(1)	05/04/2	10-05-26	
	110	Prime as per QSE 005 Primer B 114013	RT	10-05-31	x1			
		QC14+ <del>QC5</del> m	ml	10-06-01	(1)			
		Re Wing Walk B 114432	RT	10-06-01				
		QC3	BR	10-6-01	(1)			

Part No: D350-600-242 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DATE		STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-06-01		110	Re assemble spacepod install new label 3567-2 B39678 2464 B48173 QC5	RT	10-06-01	②		
				S	10-06-01	H		

Part No: D350-600-242 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 56459

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Item ID: D350-600-242

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod, RH, AS350/355

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Cust Item ID:

Required Date: 24/03/2010 Req'd Qty: 1.00



Customer:

Reference: Return 2009 / RA109114

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

0.00

0.00

Memo

Batch already pulled onto this w/o.  
jm 10/02/24

*10-02-24*

125 - QC4 inspect Kit + Labels.

*8/10/06/15*

*(H)*

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Item ID: D350-600-242

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod, RH, AS350/355

Start Date: 2/24/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/24/10 Req'd Qty: 1.00



Customer:

Reference: Return 2009 / RA109114

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 		0.00							
QC Quality Control	Memo Batch already pulled onto this w/o. jrn 10/02/24	0.00							

10-6-22 SP

130 - ID & STOCK UNDER NEW B/N @ CH6001

135 -

QC 21

10/06/22 HJ  
u 10-06-22

# Picklist Print

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16

Work Order ID: 56459



Parent Item: D350-600-242



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 2/24/10

Required Date: 3/24/10

Comments: IPP Rev: A 107.03.07 new issue EC  
 IPP rev B 07.04.16 reformat, D3188 rev.E EC  
 IPP Rev: C 08-09-30 add primer in step 44 DD verified by: EC IPP Rev: D  
 add install insert seq150 DD 10.03.15 verified by: EC IPP Rev: E remove

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130 Purchased No 110 Each 1,778.000 28.0000



Insert

*MA*

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST282

1778

110511

38

114407

1740

AN526C832R10 Purchased No 150 Each 225.0000 8.0000



Screw

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST327

225

104603

25

113154

100

113288

50

114382

50

# Picklist Print

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Work Order ID: 56459

Parent Item: D350-600-242

Parent Item Name: Spacepod, RH, AS350/355

Start Date: 2/24/10

Required Date: 3/24/10

Comments: IPP Rev: A 107.03.07 new issue EC  
 IPP rev B 07.04.16 reformat, D3188 rev.E EC  
 IPP Rev: C 08-09-30 add primer in step 44 DD verified by: EC IPP Rev: D  
 add install insert seq150 DD 10.03.15 verified by: EC IPP Rev: E remove

Start Qty: 1.00

Required Qty: 1.00

AN526C832R10 Purchased No 200 Each 225.0000 2.0000



Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST327 225

104603 25

113154 100

113288 50

114382 50

AN526C832R14 Purchased No 150 Each 760.0000 2.0000



Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST327 760

104916 760

AN526C832R24 Purchased No 140 Each 76.0000 4.0000



screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST327 76

110179 76

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Work Order ID: 56459

Parent Item: D350-600-242

Parent Item Name: Spacepod, RH, AS350/355

Start Date: 2/24/10

Required Date: 3/24/10

Comments: IPP Rev: A 07.03.07 new issue EC  
IPP rev B 07.04.16 reformat, D3188 rev.E EC  
IPP Rev: C 08-09-30 add primer in step 44 DD verified by: EC IPP Rev: D  
add install insert seq150 DD 10.03.15 verified by: EC IPP Rev: E remove

Start Qty: 1.00

Required Qty: 1.00

AN960JD10	Purchased	No	150	Each	0.0000	2.0000
Washer						
AN960JD516	Purchased	No	140	Each	0.0000	1.0000
Washer						
AN960JD516	Purchased	No	200	Each	0.0000	2.0000
Washer						
AN960JD8	Purchased	No	140	Each	0.0000	4.0000
Washer						
AN960JD8	Purchased	No	150	Each	0.0000	16.0000
Washer						
AN960JD8	Purchased	No	200	Each	0.0000	12.0000
Washer						
D2179	Manufactured	No	140	Each	59.0000	2.0000
Doubler						

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST007

59

35432

59

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Shop Packet Print

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# Picklist Print

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Work Order ID: 56459



Parent Item: D350-600-242



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 2/24/10

Required Date: 3/24/10

Comments: IPP Rev: A 07.03.07 new issue EC  
 IPP rev B 07.04.16 reformat, D3188 rev.E EC  
 IPP Rev: C 08-09-30 add primer in step 44 DD verified by: EC IPP Rev: D  
 add install insert seq150 DD 10.03.15 verified by: EC IPP Rev: E remove

Start Qty: 1.00

Required Qty: 1.00

D2228 Manufactured No 150 Each 58.0000 4.0000



Bracket Plate



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST009 58

30679 11

48228 47

Manufactured No 140 Each 93.0000 2.0000

D2237



Striker Plate



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST009 40

57255 40

Main Warehouse

ST010 53

55006 4

55312 49

# Picklist Print

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Parent Item Name: Spacepod, RH, AS350/355

Start Date: 2/24/10

Required Date: 3/24/10

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 IPP rev B 07.04.16 reformat, D3188 rev.E EC  
 IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D  
 add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Qty: 1.00

Required Qty: 1.00

D2464 Manufactured No 150 f 393.7500 11.3684



3/4 Seal



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST402

393.75

48173

393.75

Manufactured No

150

Each

105.0000

2.0000

D2585



Mounting Channel



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST018

62

53798

2

55313

60

Main Warehouse

ST019

43

56524

43

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Start Date: 2/24/10

Required Date: 3/24/10

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 IPP rev B 07.04.16 reformat, D3188 rev.E EC  
 IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D  
 add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Qty: 1.00

Required Qty: 1.00

D2586 Manufactured No 150 Each 83.0000 2.0000



Door Latch



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST204

83

55314

83

D2621 Manufactured No 150 Each 116.0000 2.0000



Latch Plate, 350 Spacepod



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST021

116

46842

47

56526

69

D2857-1 Manufactured No 150 Each 37.0000 1.0000



Hinge Bracket



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST026

37

55819

18

56529

19

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# Picklist Print

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Work Order ID: 56459



Parent Item: D350-600-242



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 2/24/10

Required Date: 3/24/10

Comments: IPP Rev:A 107.03.07 new issue EC  
 IPP rev B 07.04.16 reformat, D3188 rev.E EC  
 IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D  
 add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Qty: 1.00

Required Qty: 1.00

D2857-2 Manufactured No 150 Each 47.0000 1.0000



Hinge Bracket

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST027

47

55020

27

56530

20

D2985 Manufactured No 200 Each 13.0000 1.0000



Label

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST032

13

48236

3

50232

10

D2986 Manufactured No 140 sf 0.0000 5.9158



Black Neoprene Foam .125

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Work Order ID: 56459



Parent Item: D350-600-242



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 2/24/10

Required Date: 3/24/10

Comments: IPP Rev:A 07.03.07 new issue EC  
 IPP rev B 07.04.16 reformat, D3188 rev.E EC  
 IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D  
 add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Qty: 1.00

Required Qty: 1.00

D3015-3 Manufactured No 130 Each 122.0000 1.0000  
 Locknut

*N/A*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST033	122	
43758	26	
48238	2	
56701	94	

D350-600-449 Manufactured No 200 Each 2.0000 1.0000  
 Switch Relocation



*CT167001*

*B57743*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FG120	2	
50244	2	

D3538-1 Manufactured No 140 Each 28.0000 2.0000  
 Hinge Bracket



*N/A*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST069	28	
55012	12	
56092	4	
56531	12	

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Work Order ID: 56459



Parent Item: D350-600-242



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 2/24/10

Required Date: 3/24/10

Comments: IPP Rev:A 07.03.07 new issue EC  
 IPP rev B 07.04.16 reformat, D3188 rev.E EC  
 IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D  
 add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Qty: 1.00

Required Qty: 1.00

D3554-7 Manufactured No 140 Each 41.0000 1.0000



Ball Stud

*N/A*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST070

41

37674

41

200

Each

41.0000

1.0000



D3554-7



Ball Stud

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST070

41

37674

41

150

Each

18.0000

1.0000



D3557-1



Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST070

18

46887

3

50283

15

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Work Order ID: 56459



Parent Item: D350-600-242



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 2/24/10

Required Date: 3/24/10

Comments: IPP Rev: A 107.03.07 new issue EC  
 IPP rev B 07.04.16 reformat, D3188 rev.E EC  
 IPP Rev: C 08-09-30 add primer in step 44 DD verified by: EC IPP Rev: D  
 add install insert seq150 DD 10.03.15 verified by: EC IPP Rev: E remove

Start Qty: 1.00

Required Qty: 1.00

D3567-2

Manufactured No

140

Each

27.0000

1.0000



Decal

*Handwritten signature/initials*

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST070

27

39678

8

50375

19

D3567-2

Manufactured No

150

Each

27.0000

1.0000



Decal

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST070

27

39678

8

50375

19

K10021

Manufactured No

200

Each

1.0000

1.0000



Spacepod Hardware Kit (-241)

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST122

1

57814

1

*Handwritten notes: 355407 and a signature*

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Parent Item: D350-600-242



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 IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D  
 add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-5

Purchased

No

140

Each

6,118.000 4.0000



Rivet

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST317

6118

6733

1136

6874

4982

MS21042L08

Purchased

No

150

Each

649.0000 18.0000



Nut

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST300

400

114330

400

Main Warehouse

ST301

249

114056

49

114227

200

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Work Order ID: 56459



Parent Item: D350-600-242



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 2/24/10

Required Date: 3/24/10

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 IPP rev B 07.04.16 reformat, D3188 rev.E EC  
 IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D  
 add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

200

Each

649.0000

14.0000



Nut

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST300

400

114330

400

Main Warehouse

ST301

249

114056

49

114227

200

*N/A*

MS21042L3

Purchased

No

150

Each

996.0000

2.0000



Nut

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST300

996

113537

46

113644

950

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Parent Item: D350-600-242



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 2/24/10

Required Date: 3/24/10

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 IPP rev B 07.04.16 reformat, D3188 rev.E EC  
 IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D  
 add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-11

Purchased

No

150

Each

117.0000 2.0000



Screw



M113749 \*25

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST288

50

114382

50

Main Warehouse

ST290

67

111977

17

113749

50

MS27039-1-15

Purchased

No

150

Each

135.0000 2.0000



Screw



## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST292

135

112794

35

114056

100

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Parent Item: D350-600-242



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 2/24/10

Required Date: 3/24/10

Comments: IPP Rev:A 07.03.07 new issue EC  
 IPP rev B 07.04.16 reformat, D3188 rev.E EC  
 IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D  
 add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3

Purchased

No

150

Each

148.0000

2.0000



Washer



M11268 x2

sl

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST277

148

111268

148

D3188-2M

Manufactured

No

110

Each

2.0000

1.0000



SPACEPOD BODY RH



## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

CA

2

46180A

1

53076

1

D3186-4

Manufactured

No

110

Each

0.0000

1.0000



Spacepod Door, RH



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Parent Item: D350-600-242



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 2/24/10

Required Date: 3/24/10

Comments: IPP Rev:A 07.03.07 new issue EC  
 IPP rev B 07.04.16 reformat, D3188 rev.E EC  
 IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D  
 add install insert seq150 DD 10.03.15 verified by:EC IPP Rev:E remove

Start Qty: 1.00

Required Qty: 1.00

D3187-2 Manufactured No 110 Each 2.0000 1.0000



Spacepod Floor

359579 (SL) 5

Warehouse  
Location

Main Warehouse

ST241B

2

31836

2

110

Each

580.0000

8.0000

A3235-020-935

Purchased

No



Washer - Countersunk

Warehouse  
Location

Main Warehouse

ST281

580

106150

580

200

Each

122.0000

1.0000

D3015-3



Locknut

Manufactured No

Warehouse  
Location

Main Warehouse

ST033

122

43758

26

48238

2

56701

94

April 26, 2010 11:24:18 AM

Shop Packet Print

REFERENCE ONLY

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
X									D350-600-241	SPACEPOD™ LH, AS350
	X								D350-600-242	SPACEPOD™ RH, AS350/355
		X							D355-600-243	SPACEPOD™ LH, AS355
1		1	X						D350-600-245	DOOR ASSEMBLY LH
	1			X					D350-600-246	DOOR ASSEMBLY RH
					X				D350-600-247	SPACEPOD™ UPGRADE KIT LH
						X			D350-600-248	SPACEPOD™ UPGRADE KIT RH
							X		D350-600-249	SPACEPOD™ UPGRADE KIT
1	1	1						X	D350-600-449	SWITCH RELOCATION KIT
2	2	2							D2174-041	WEB ASSEMBLY
							1		D2464-0360	NEOPRENE SEAL
			1	1					D2589	KEYS, KEY CHAIN
1	1	1							D2985	DECAL
1	1	1			1	1	1		D3015-3	LOCK NUT
			1		1				D3186-3	SPACEPOD DOOR, LH
				1		1			D3186-4	SPACEPOD DOOR, RH
1**		1**							D3187-1	FLOOR
	1**								D3187-2	FLOOR
1									D3188-5	SPACEPOD BODY
	1								D3188-6	SPACEPOD BODY
		1							D3188-7	SPACEPOD BODY
1	1	1			1	1	1		D3547-1	BRACKET
1	1	1			1	1	1		D3550-1	STRUT
			1	1	1	1	1		D3552-7	GAS SPRING
1	1	1			1	1	1		D3554-7	BALL STUD
8	8	8							AN3-3A	BOLT
2	2	2							AN3-10A	BOLT
8	8	8							AN3H4	BOLT
1	1	1			1	1	1		AN5-5A	BOLT
36	36	36							AN525-10R7	SCREW
8	8	8			4	4	4		AN526C832R14	SCREW
7	7	7							MS24694S67	SCREW
1	1	1			1	1	1		MS24694S69	SCREW
			2	2	2	2	2		MS27039-0811	SCREW
8	8	8			1	1	1		AN3235-020-935	WASHER
8	8	8							AN960JD10	WASHER
16	16	16			1	1	1		AN960JD10L	WASHER
			4	4	8	8	8		AN960JD8	WASHER
3	3	3			3	3	3		AN960JD516	WASHER
			2	2	2	2	2		NAS1515H3	NYLON WASHER
			2	2	6	6	6		MS21042L08	NUT
16	16	16			1	1	1		MS21042L3	NUT (or MS21042-3)
1	1	1			1	1	1		MS21042L5	NUT
16	16	16							AKS7-1032-130	INSERT
28**	28**	28**							AKS7-1032-130	INSERT
								3	M81824/1-2	SPLICE

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Revision: E

Date: 09.07.31

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
								2	D3597-1	FEMALE SPADE CONNECTOR
								1	D3598-2-096	EXPANDABLE SLEEVE
								24	D3599-1	TIE-WRAP
								24	D3600-1	TIE-WRAP MOUNT
								24 FT	M22759/16-22-9	WIRE
			1*	1*	1*	1*			D2464-1250	NEOPRENE SEAL
1**		1**	1*		1*				D3567-1	DECAL
	1**			1*		1*			D3567-2	DECAL
			2*	2*					D2586	LATCH
			2*	2*					D2585	MOUNTING CHANNEL
			2*	2*					D2621	LATCH PLATE
			2*	2*					MS27039-1-15	SCREW
					2	2	1		MS27039-1-25	SCREW
			2*	2*	2	2	1		AN960JD10	WASHER
			2*	2*	2	2	1		MS21042L3	NUT (or MS21042-3)
			1*	1*					D2857-1	HINGE BRACKET
			1*	1*					D2857-2	HINGE BRACKET
			2*	2*					D2228	BACKING PLATE
			8*	8*	8	8	8		AN526C832R10	SCREW
			8*	8*	8	8	8		AN960JD8	WASHER
			8*	8*	8	8	8		MS21042L08	NUT
			1*	1*	1*	1*	1		D3557-1	BRACKET
			2*	2*	2*	2*	2		D2228	BACKING PLATE
			1*	1*	1*	1*	1		D3554-7	BALL STUD
			1*	1*	1*	1*	1		AN960JD516	WASHER
			1*	1*	1*	1*	1		D3015-3	LOCK NUT
			2*	2*	2*	2*	2		AN526C832R14	SCREW
			2*	2*	2*	2*	2		AN526C832R10	SCREW
			4*	4*	4*	4*	4		AN960JD8	WASHER
			4*	4*	4*	4*	4		MS21042L08	NUT
2**	2**	2**			1	1	1		D2237	STRIKER PLATE
4**	4**	4**			2	2	2		MS20426AD4-5	RIVET
2**	2**	2**			2	2	2		D3538-1	HINGE BRACKET
2**	2**	2**							D2179	HINGE BRACKET PLATE
4**	4**	4**			4	4	4		AN526C832R24	SCREW
4**	4**	4**			4	4	4		AN960JD8	WASHER
4**	4**	4**			4	4	4		MS21042L08	NUT

\* PRE-INSTALLED ON D3186-3/-4 SPACEPOD™ DOOR

\*\* PRE-INSTALLED ON D3188-5/-6/-7 SPACEPOD™

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Revision: E

Date: 09.07.31

**Work Order ID 56459**

February 24, 2010

Page 1

Item ID: D350-600-242

Revision ID:

Item Name: Spacepod, RH, AS350/355

Draw Nbr: IIN D350-600

Revision Nbr: Rev C

Start Date: 24/02/2010

Start Qty: 1.00

Required Date: 24/03/2010

Reqd Qty: 1.00

Reference: Return 2009 / RA109114

Cust Item ID:

Customer ID:

Description:

Sales Order:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Hours**

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
-------------	----------------	-----------------------	--------	-----	-------------	-----------	-----------	------------	------------	---------------	-------------

All N/A's were in  
original kit (return)  
Highlighted parts were  
added to complete kit

REFERENCE ONLY

# Work Order Summary

April 26, 2010 9:56:59 AM

Page 1 of 1

Criteria : Work Order ID: 56459 Item ID: D350-600-242 Product Family SMALL FAB  
 Work Order Start Dates 2/24/10 to 2/24/10 11:59:59 PM Work Order Required Dates 3/24/10 to 3/24/10  
 11:59:59 PM  
 Reference: Return 2009 / RA109114  
 Work Order Status Released

<b>Work Order ID</b>	56459	<b>Required Qty</b>	1.0000	<b>Status Code</b>	Released
<b>Item ID</b>	D350-600-242	<b>Accepted Qty</b>	0.0000	<b>Scrap Qty</b>	0.0000

**Item Name** Spacepod, RH, AS350/355

**Current Acct Value** \$5,155.396

**Sales Order ID**

<b>Start Date</b>	2/24/10	<b>Required Date</b>	3/24/10	<b>Completed Date</b>
-------------------	---------	----------------------	---------	-----------------------

Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
<b>Direct Costs</b>	<b>Total</b>	<b>Each</b>	<b>Each</b>	<b>Each</b>	<b>Each</b>
<b>Material</b>	\$3,947.998	\$0.000	\$3,947.998	\$3,947.998	100.00%
<b>Labor</b>	\$1,009.406	\$0.000	\$1,009.406	\$1,009.406	100.00%
<b>Outplant</b>	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
<b>Variable Burden</b>	-\$17.742	\$0.000	-\$17.742	-\$17.742	100.00%
<b>Fixed Burden</b>	\$3,626.974	\$0.000	\$3,626.974	\$3,626.974	100.00%
<b>Material Burden</b>	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
<b>** Total **</b>	\$8,566.635	\$0.000	\$8,566.635	\$8,566.635	

Item ID/ Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
D350-600-242	1.0000				
Spacepod, RH, AS350/355			2/24/10	1.0000	\$8,566.635
<b>Total Matl Amts:</b>					\$8,566.635

## Work Center Eng

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
titl01												
3/01/10												
110			0.00	0.00	0.00	0.00	1.00	\$0.000	\$0.000	\$0.000	\$0.000	\$0.00
110			0.00	0.00	0.00	0.00	1.00	\$0.000	\$0.000	\$0.000	\$0.000	\$0.00
<b>Total:</b>			0.00	0.00	0.00	0.00	2.00	\$0.000	\$0.000	\$0.000	\$0.000	\$0.00

April 26, 2010 9:56:59 AM

Work Order Summary

Page 1 of 1



# Work Order ID 48152

Friday, June 26, 2009 9:18:37 AM



REFERENCE ONLY

Page 1

Item ID: D350-600-242

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacepod, RH, AS350/355

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 09/10/13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D350-600	Rev C								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Sc 10/12

\*

Document Control

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

110

0.00



Small Fab

Small Fab

Memo

0.00

PT 09-10-19

Small Fab

1-Drill holes in D3188-2 using drill jig DT8971 2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188 3-Deburr 4-Install inserts in D3188-2 as per Dwg D3188.

120

0.00



QC5- Inspect part completeness to step on W/O

Sc 10/12

QC

Memo

0.00

Quality Control



**Work Order ID 48152**

Friday, June 26, 2009 9:18:37 AM

**REFERENCE ONLY**

Page 2

Item ID: D350-600-242

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacepod, RH, AS350/355

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut D2986 Neoprene Foam per template D2986T1

NA as per B# 48237  
RT 09.10.17

(PTO)

140

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

\*\*\*\*This step separates hardware, previous steps is for body &amp; floor\*\*\*\*

150

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600

☐

\*\*\*Hardware on previous steps is for door ass'y\*\*\*\*☐ 1-Drill and plug section I-I  
and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to  
weight.☐ A/R Hysol batch: \_\_\_\_\_

Hysol 956 B112167



SEE

W/D

CHG



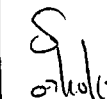


milled

Fibres m 100859

OVER

RT 09.10.17

Dart Aerospace Ltd

W/O: 48152		WORK ORDER CHANGES		REFERENCE ONLY			
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.10.14	150	Acceptable to substitute EA956 FOR EA934 FOR DRILLING THROUGH HOLES @ SECTION I-745-5 OF DWG D3188. <del>Permanent change</del>				 09.10.14 per Q51042	 07/10/14
09-10-14	130	Adhere D2986 neoprene foam to bottom side of D3187-2 spaced floor using contact adhesive B 112225	ET	09-10-14	1		 07/10/14
				09/10/23			

Part No: D350-600-242 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 48152

Friday, June 26, 2009 9:18:37 AM

Page 3

Item ID: D350-600-242

Accept

Revision ID: C

Item Name: Spacepod, RH, AS350/355

Start Date: 7/15/2009 Start Qty: 1.00

Required Date: 8/3/2009 Req'd Qty: 1.00

Cust Item ID:




Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish <i>also S</i> Memo	0.00 0.00							
170  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	<i>501/1/19</i>			<i>(X)</i>	<i>f</i>		
180  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 <i>Wing w/c, S</i> Memo	0.00 0.00	<i>MO 09110119</i>			<i>(X)</i>			

REFERENCE ONLY

## Work Order ID 48152

Friday, June 26, 2009 9:18:37 AM

Page 4

Item ID: D350-600-242

Accept

Revision ID: C

Item Name: Spacepod, RH, AS350/355

Start Date: 7/15/2009 Start Qty: 1.00

Required Date: 8/3/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190 QC3- Inspect Part Finish

0.00

BR 06-11-19

①.

QC

Memo

0.00

Quality Control

200 QC4- 100% Inspect kits for completeness

0.00

Pick kit 6

Memo

0.00

QC

Quality Control

PTO

210 QC4- 100% Inspect kits for completeness

0.00

28010/20

0.00

QC

Memo

Quality Control

④

/

REFERENCE ONLY

W/O: 48152		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-10-19	200	Perm. Change add to pick list MS21042LOB x 14 AN9603DB x 12	<u>m 112492</u> <u>m 111578</u>	09-10-19			S 02/01/19
				09/10/23			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 48152

Friday, June 26, 2009 9:18:37 AM

Page 5

Item ID: D350-600-242

Accept

Setup Start

Revision ID: C

Stop

Item Name: Spacepod, RH, AS350/355

Start Date: 7/15/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00

Customer:



Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-600-141								
	Location: _____								
	PPP Rev: _____								
230	QC21- Final Inspection - Work Order Release	0.00							
									
QC	Memo	0.00							
Quality Control									

W 9-10-23

# Picklist Print

Friday, June 26, 2009 9:18:36 AM

REFERENCE ONLY

Page 1

Work Order ID: 48152

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355

Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ ALS4-1032-130		Purchased	No			110	Each	0.0000	28.0000			
Insert												
✓ D3186-4RevD		Manufactured	No			110	Each	0.0000	1.0000			
Spacepod Door, RH												
✓ D3187-2RevC		Manufactured	No			110	Each	0.0000	1.0000			
Spacepod Floor												
✓ D3188-2MRevE		Manufactured	No			110	Each	0.0000	1.0000			
SPACEPOD BODY RH												
✓ D3015-3RevB		Manufactured	No			120	Each	0.0000	1.0000			
Locknut												
✓ A3235-020-935		Purchased	No			130	Each	0.0000	8.0000			
Washer - Countersunk												
✓ AN526C832R24		Purchased	No			140	Each	0.0000	4.0000			
screw												
✓ AN960JD516		Purchased	No			140	Each	0.0000	1.0000			
Washer												
✓ AN960JD8		Purchased	No			140	Each	0.0000	4.0000			
Washer												

M110511

SL

48152 B 01 RT 09-10-13

B31836

SP

48152 A RT 09-10-13

48238

SL

M106150

SL

M110179

SL

M112794

SL

M111578

SL

9/10/14



# Picklist Print

REFERENCE ONLY

Page 2

Friday, June 26, 2009 9:18:36 AM

Work Order ID: 48152

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355












Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D2179RevB 		Manufactured	No			140	Each	0.0000	2.0000			
Doubler												
✓ D2237RevD1 		Manufactured	No			140	Each	0.0000	2.0000			
Striker Plate												
✓ D2986RevB 		Manufactured				140	sf	0.0000	5.9158			
Black Neoprene Foam .125												
✓ D3015-3RevB 		Manufactured	No			140	Each	0.0000	1.0000			
Locknut												
✓ D3538-1RevA 		Manufactured	No			140	Each	0.0000	2.0000			
Hinge Bracket												
✓ D3554-7RevA 		Manufactured	No			140	Each	0.0000	1.0000			
Ball Stud												
✓ D3567-2RevA 		Manufactured	No 			140	Each	0.0000	1.0000			
Decal												
✓ MS20426AD4-5 		Purchased	No			140	Each	0.0000	4.0000			
Rivet												
✓ AN526C832R10 		Purchased	No			150	Each	0.0000	8.0000			
Screw												

B35432 SP

B50348 SP

48237 SP

37674 SP

B48197 SP

B37674 SP

B39678 SP

6733 SP

M104603 SP  
9/10/14 SP

Friday, June 26, 2009 9:18:36 AM

Shop Packet Print

Page 2

# Picklist Print

REFERENCE ONLY

Page 3

Friday, June 26, 2009 9:18:36 AM

Work Order ID: 48152

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355










Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN526C832R14 		Purchased	No			150	Each	0.0000	2.0000			34
Screw												
✓ AN960JD10 		Purchased	No			150	Each	0.0000	2.0000			50
Washer												
✓ AN960JD8 		Purchased	No			150	Each	0.0000	4.0000			50
Washer												
✓ D2228RevB 		Manufactured	No			150	Each	0.0000	4.0000			54
Bracket Plate												
✓ D2464RevB 		Manufactured	No			150	f	0.0000	11.3684			39669 ✓
3/4 Seal												
✓ D2585RevB 		Manufactured	No			150	Each	0.0000	2.0000			50
Mounting Channel												
✓ D2586RevD 		Manufactured	No			150	Each	0.0000	2.0000			50
Door Latch												
✓ D2621RevB 		Manufactured	No			150	Each	0.0000	2.0000			50
Latch Plate, 350 Spacepod												
✓ D2857-1RevB 		Manufactured	No			150	Each	0.0000	1.0000			50
Hinge Bracket												

Friday, June 26, 2009 9:18:36 AM

Shop Packet Print

Page 3

# Picklist Print

REFERENCE ONLY

Page 4

Friday, June 26, 2009 9:18:36 AM

Work Order ID: 48152

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355










Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D2857-2RevB 		Manufactured	No			150	Each	0.0000	1.0000			SP
Hinge Bracket												
✓ D3557-1RevA 		Manufactured	No			150	Each	0.0000	1.0000			SD
Bracket												
✓ D3567-2RevA 		Manufactured	No			150	Each	0.0000	1.0000			SD
Decal												
✓ MS21042L08 		Purchased	No			150	Each	0.0000	4.0000			SD
Nut												
✓ MS21042L3 		Purchased	No			150	Each	0.0000	2.0000			SD
Nut												
✓ MS27039-08-11 		Purchased	No			150	Each	0.0000	2.0000			SD
Screw												
✓ MS27039-1-15 		Purchased	No			150	Each	0.0000	2.0000			SD
Screw												
✓ NAS1515H3 		Purchased	No			150	Each	0.0000	2.0000			SD
Washer												
✓ AN526C832R10 		Purchased	No			200	Each	0.0000	2.0000			SP
Screw												

Friday, June 26, 2009 9:18:36 AM

Shop Packet Print

Page 4

# Picklist Print

Friday, June 26, 2009 9:18:36 AM

REFERENCE ONLY

Page 5

Work Order ID: 48152

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN960JD516 <i>GOOD</i>		Purchased	No			210	Each	0.0000	2.0000			
Washer												
✓ D2985RevA1 <i>CANNOT FIND</i>		Manufactured	No			210	Each	0.0000	1.0000			
Label												
✓ D350-600-449RevC <i>Scrap</i>		Manufactured	No			210	Each	0.0000	1.0000			
Switch Relocation												
✓ D3547-1RevA <i>GOOD</i>		Manufactured	No			210	Each	0.0000	1.0000			
Bracket												
✓ D3550-1RevB <i>Scrap</i>		Manufactured	No			210	Each	0.0000	1.0000			
Strut												
✓ D3552-7RevD <i>GOOD</i>		Manufactured	No			210	Each	0.0000	1.0000			
Door Prop												
✓ D3554-7RevA <i>GOOD</i>		Manufactured	No			210	Each	0.0000	1.0000			
Ball Stud												
✓ K10021RevN/A <i>-Scrap</i>		Manufactured	No			210	Each	0.0000	1.0000			
Spacepod Hardware Kit (-241)												

REFERENCE ONLY

FLOOR IS SCRAP

M112794

B48236

47203

B35455

B48367

B32644

B37674

B50276

9/10/14

Date: Friday, 22/05/2009 4:45:00 PM  
User: Julie Dawson

# **Process Sheet**

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SPACEPOD ASSEMBLY RH/ DSI 9335	
<b>Job Number</b> :	48152			
<b>Estimate Number</b> :	12779			
<b>P.O. Number</b> :		<b>Part Number</b> :	D350600242	
<b>This Issue</b> :	22/05/2009	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	IIN REV.C PG11,18-21	
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A	
<b>Previous Run</b> :	47002	<b>Drawing Revision</b> :	C	
		<b>Material</b> :		
<b>Written By</b> :		<b>Due Date</b> :	26/06/2009	<b>Qty:</b> 1 Um: Each
<b>Checked &amp; Approved By</b> :	JULIE DAWSON			
<b>Comment</b> :	Est Rev:A 07.03.07 new issue EC est rev B 07.04.16 reformat, D3188 rev.E EC Est Rev:C 08-09-30 add primer in step 44 DD verified by:EC			

## **Additional Product**

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0

✓ DC

DOCUMENT CONTROL



**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

2.0

✓ 48152A

SPACEPOD BODY RH



**Comment:** Sub-Component SPACEPOD BODY RH

1 x D3188-2M, Batch

3.0

✓ 48152B

SPACEPOD DOOR RH



**Comment:** Sub-Component SPACEPOD DOOR RH

1 x D3186-4 Batch

4.0

✓ D31872

Spacepod Floor



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1 D3187-2

Floor

5.0

✓ ALS41032130

Insert



**Comment:** Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

insert

batch:

REFERENCE ONLY

Date: Friday, 22/05/2009 4:45:00 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

✓ A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer - Countersunk

7.0

✓ SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes in D3188-2 using drill jig DT8971

2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188

3-Deburr

4-Install inserts in D3188-2 as per Dwg D3188.

8.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

✓ D29861

Rubber Spacer



Comment: Qty.: 1.0500 Each(s)/Unit Total : 1.0500 Each(s)

neoprene foam

batch: \_\_\_\_\_

10.0

✓ SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

11.0

✓ D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: \_\_\_\_\_

12.0

✓ D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

REFERENCE ONLY

Date: Friday, 22/05/2009 4:45:00 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

✓ AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

BATCH: \_\_\_\_\_

14.0

✓ D35672

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: \_\_\_\_\_

15.0

✓ D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: \_\_\_\_\_

16.0

✓ MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Batch: \_\_\_\_\_

17.0

✓ D35381

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch: \_\_\_\_\_

18.0

✓ D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: \_\_\_\_\_

19.0

✓ AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: \_\_\_\_\_

REFERENCE ONLY

Date: Friday, 22/05/2009 4:45:00 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

✓ AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: \_\_\_\_\_

21.0

✓ MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: \_\_\_\_\_

22.0

✓ SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

\*\*\*\*This step separates hardware, previous steps is for body & floor\*\*\*\*

23.0

✓ MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: \_\_\_\_\_

24.0

✓ AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: \_\_\_\_\_

25.0

✓ NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: \_\_\_\_\_

26.0

✓ MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: \_\_\_\_\_

REFERENCE ONLY



Date: Friday, 22/05/2009 4:45:00 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

✓ D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch: \_\_\_\_\_

28.0

✓ D35672

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: \_\_\_\_\_

29.0

✓ D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Door Latch

batch: \_\_\_\_\_

30.0

✓ D2585

Mounting Channel



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Clamp

batch: \_\_\_\_\_

31.0

✓ D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate

batch: \_\_\_\_\_

32.0

✓ MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: \_\_\_\_\_

33.0

✓ AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: \_\_\_\_\_

REFERENCE ONLY

Date: Friday, 22/05/2009 4:45:00 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0



MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: \_\_\_\_\_

35.0



D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: \_\_\_\_\_

36.0



D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: \_\_\_\_\_

37.0



D2228

Bracket Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Backing Plate

batch: \_\_\_\_\_

38.0



AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: \_\_\_\_\_

39.0



AN960JD8

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: \_\_\_\_\_

40.0



MS21042L08

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: \_\_\_\_\_

REFERENCE ONLY

Date: Friday, 22/05/2009 4:45:01 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

✓ D35571

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: \_\_\_\_\_

42.0

✓ AN526C832R14

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: \_\_\_\_\_

43.0

✓ AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: \_\_\_\_\_

44.0

✓ SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600

\*\*\*Hardware on previous steps is for door ass'y\*\*\*\*

1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to weight.

A/R Hysol batch: \_\_\_\_\_ expire date: \_\_\_\_\_

A/R Milled fibres batch: \_\_\_\_\_

2- Prime (grey) as necessary per QSI005

Primer batch: \_\_\_\_\_

Hardner batch: \_\_\_\_\_

3-Attach Neoprene Foam to floor using Contact Cement

A/R Contact Cement Batch: \_\_\_\_\_

45.0

✓ QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

REFERENCE ONLY

Date: Friday, 22/05/2009 4:45:01 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

46.0

✓

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

47.0

✓

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: \_\_\_\_\_

48.0

✓

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

49.0

✓

K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

50.0

✓

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

51.0

✓

D350600449

Switch Relocation



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SWITCH RELOCATION KIT

47203

52.0

✓

D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label

batch: 48236

53.0

✓

D35471

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: 35455

REFERENCE ONLY

Date: Friday, 22/05/2009 4:45:01 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

✓ D35501

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STRUT

batch: 48367

55.0

✓ D35527

Gas Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch: 32614

56.0

✓ D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: 37674

57.0

✓ AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: 112794

58.0

✓ D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: 48238

59.0

✓ QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

60.0

✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

REFERENCE ONLY

Date: Friday, 22/05/2009 4:45:01 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

61.0

QC21

FINAL INSPECTION/W/O RELEASE

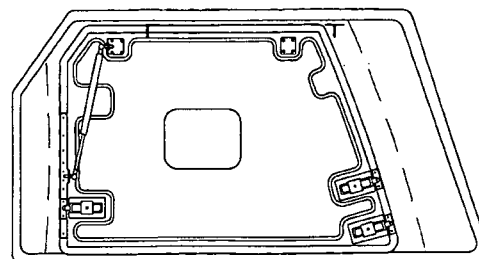
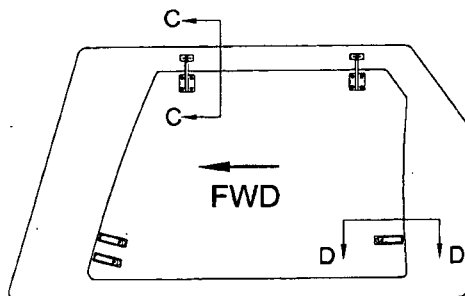


Comment: FINAL INSPECTION/W/O RELEASE

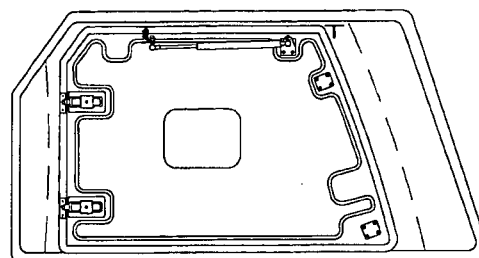
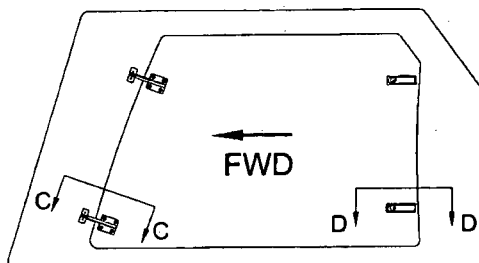
Job Completion



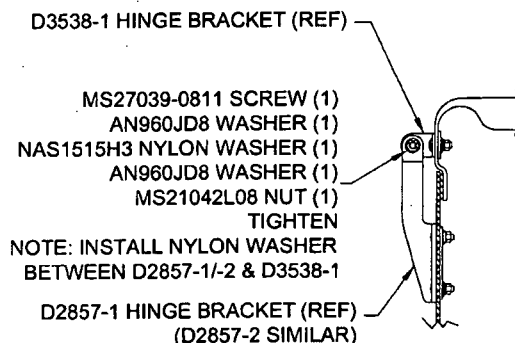
REFERENCE ONLY



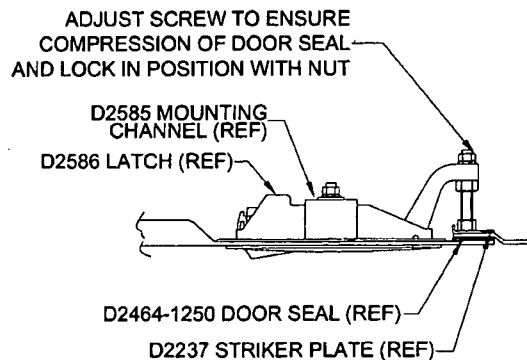
**FIGURE 6(a). -141 SPACEPOD KIT (-142 OPPOSITE, -143 SIMILAR)**  
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



**FIGURE 6(b). -241 SPACEPOD KITS (-242 OPPOSITE, -243 SIMILAR)**  
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



**SECTION 'C-C' HINGE**  
(-141 SHOWN; -142/-143/-241/-242/-243 SIMILAR)



**SECTION 'D-D' LATCH**

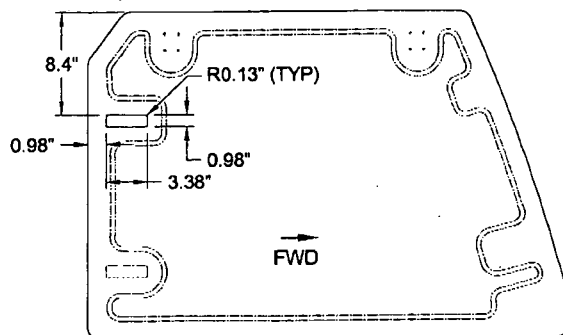
3.2.12 Re-install the following components that were removed from the aircraft in earlier steps:

- Re-install the battery shelf cover or wiring cover per the Aircraft Maintenance Manual. If it is necessary to trim the lower edge to clear the pod floor, touch up the paint using MIL-C-85285 polyurethane paint.
- If applicable, re-install the pop-out float cylinders per the Aircraft Maintenance Manual.
- Re-install the belly panel per the Aircraft Maintenance Manual.

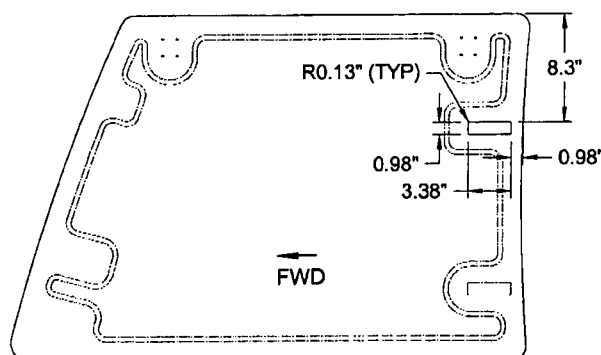
REFERENCE ONLY

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 48152

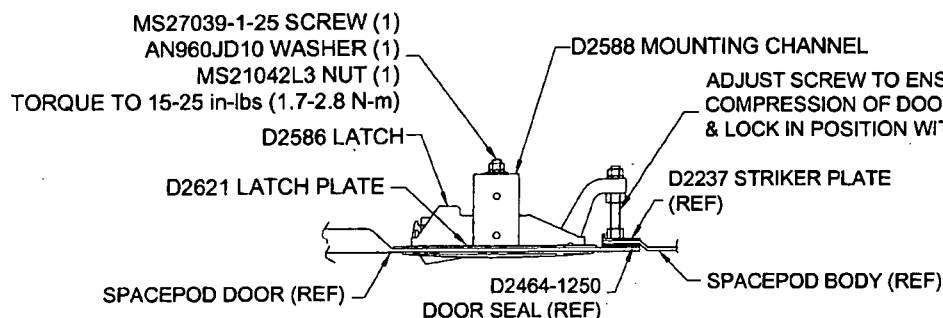
- 3.4.5 After the paint has dried, apply the D2464-1250 neoprene seal where removed in earlier steps.
- 3.4.6 Cut out the rectangular section shown in Figures 14(a) and 14(b). Install the D2586 latch, D2588 mounting channel and D2621 latch plate that were removed earlier from the door using new hardware as shown in Figure 14(c).



**FIGURE 14(a). D3186-1 SPACEPOD DOOR LATCH CUTOUT**  
(APPLICABLE FOR -041/-043/-141/-143 KITS)



**FIGURE 14(b). D3186-2 SPACEPOD DOOR LATCH CUTOUT**  
(APPLICABLE FOR -042/-142 KITS)



**FIGURE 14(c). LATCH INSTALLATION**  
(SHOWN WITH DOOR INSTALLED ON POD)

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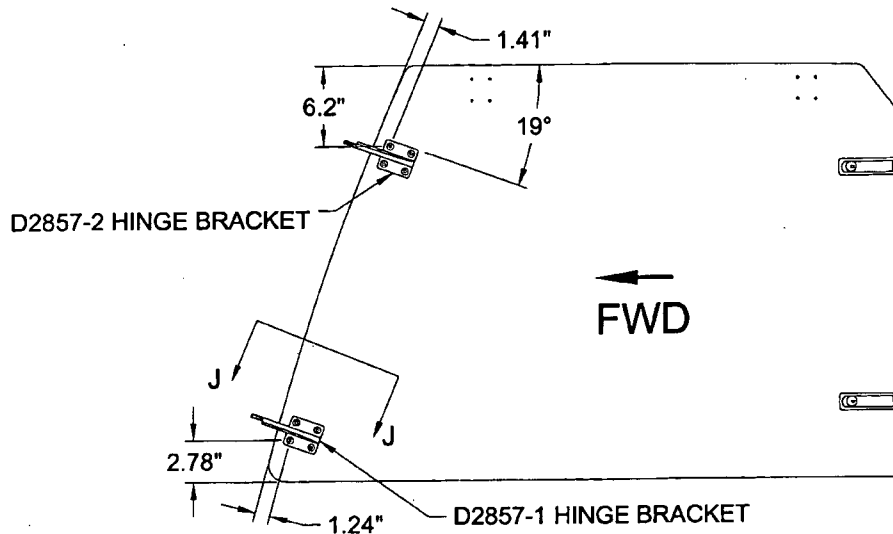
Revision: **C**  
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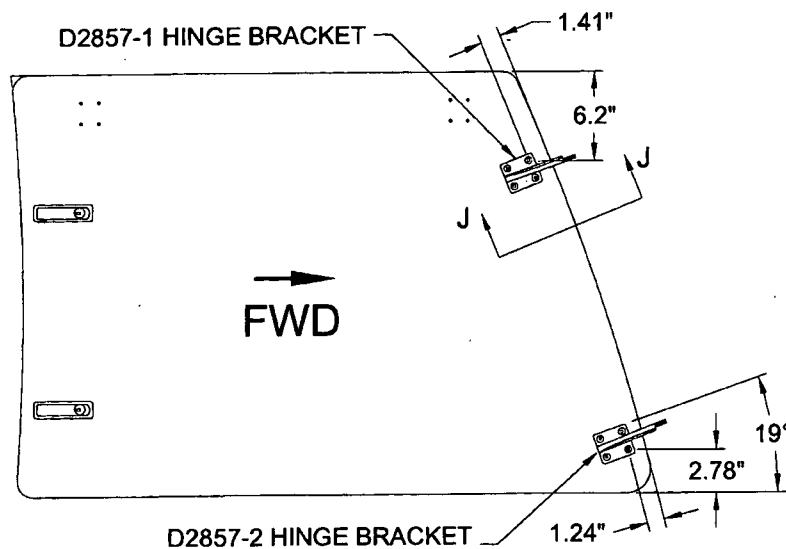
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- 3.4.7 Position the D2857-1/-2 hinge brackets as shown in Figure 15(a) for the LH side and Figure 15(b) for the RH side. Transfer drill the  $\varnothing 0.172$ " mounting holes on each bracket to the **Spacepod™** door. Install the hinge brackets as shown in Section J-J.



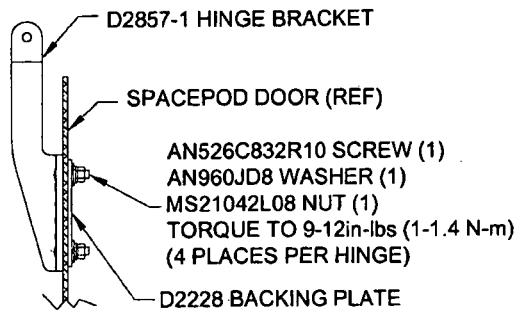
**FIGURE 15(a). HINGE BRACKET POSITION ON LH D3186-1 SPACEPOD DOOR**



**FIGURE 15(b). HINGE BRACKET POSITION ON RH D3186-2 SPACEPOD DOOR**

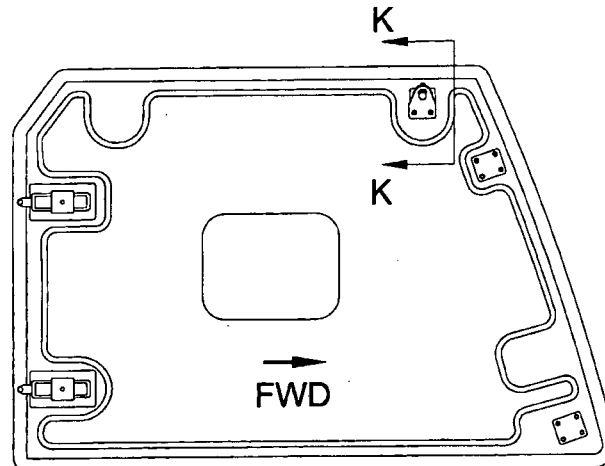
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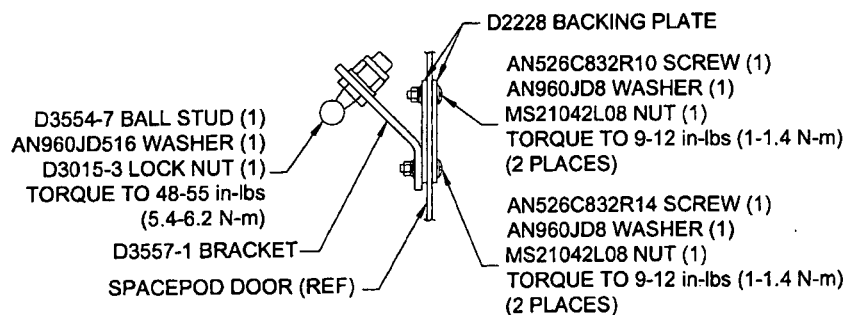


**SECTION 'J-J' HINGE BRACKET INSTALLATION**  
(D2857-1 SHOWN; D2857-2 SIMILAR)

- 3.4.8 Install the D3557-1 bracket in the existing forward hinge mounting holes with the D2228 backing plates and the D3554-7 ball stud as shown in Figure 16.



**FIGURE 16. BRACKET AND BALL STUD INSTALLATION ON SPACEPOD DOOR**  
(INSIDE OF D3186-1 SHOWN; D3186-2 OPPOSITE)



**SECTION 'K-K'**

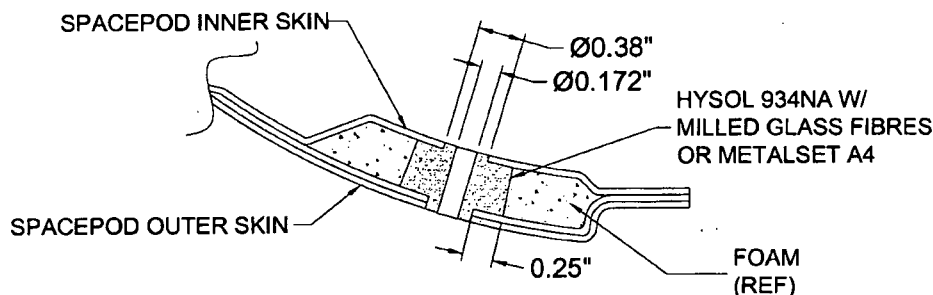
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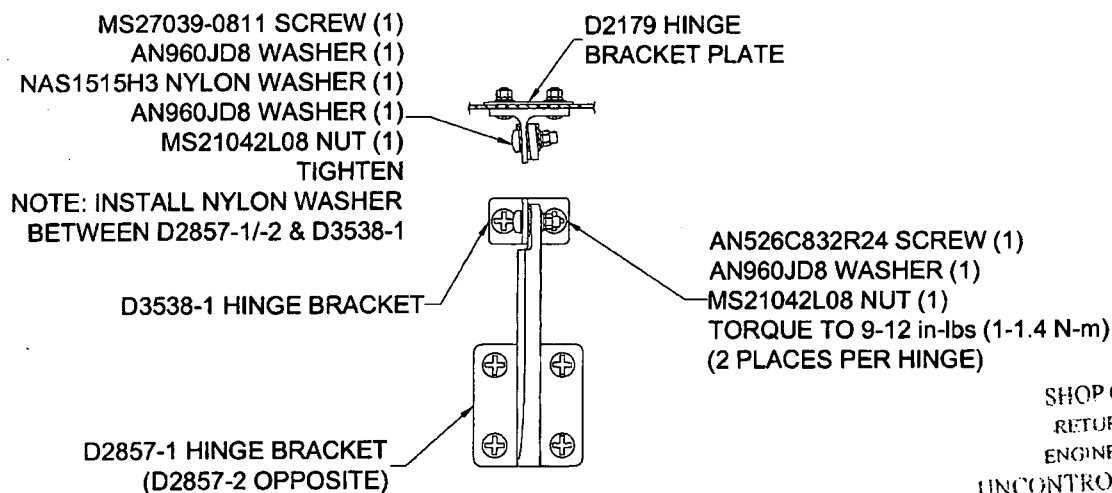
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- 3.4.9 Install the hinge brackets on the pod as shown in Figures 17(a) and 17(b):
- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown in Figure 17(b). Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the *Spacepod™* body.
  - Remove the door and drill Ø0.375" holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 17(a).
  - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to in a ratio of 10:1 or Metalset A4. Allow the material to cure.
  - Reposition the *Spacepod™* door and hinges and transfer drill the Ø0.172" D3538-1 hinge bracket mounting holes to the pod.
  - Install the hinge brackets and *Spacepod™* door as shown in Figure 17(b).



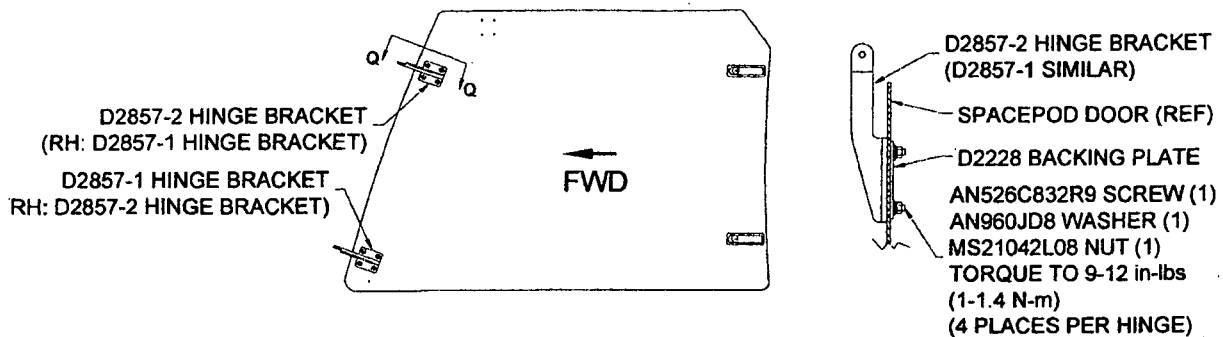
**FIGURE 17(a). COMPOSITE MODIFICATION**



**FIGURE 17(b). HINGE BRACKET INSTALLATION**  
(D2857-1 SHOWN; D2857-2 OPPOSITE)

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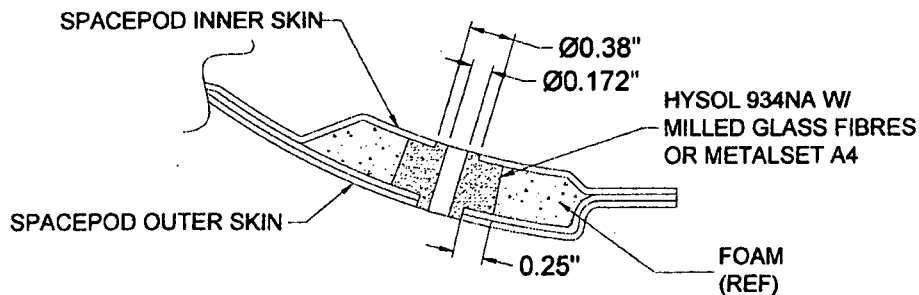
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**FIGURE 21. HINGE BRACKET INSTALLATION**  
 (-041/-141 KITS SHOWN; -043/-143 SIMILAR; -042/-142 OPPOSITE)

**SECTION 'Q-Q'**

- 3.5.5 Install the D3538-1 hinge brackets on the pod as shown in Figure 22:
- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown. Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the *Spacepod™* body.
  - Remove the door and drill  $\varnothing 0.375$ " holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 22(a).
  - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to a ratio of 10:1 or Metalset A4. Allow the material to cure.
  - Reposition the *Spacepod™* door and hinges and transfer drill the  $\varnothing 0.172$ " D3538-1 hinge bracket mounting holes to the pod.
  - Install the D3538-1 hinge brackets and *Spacepod™* door as shown in Figure 22(b).



**FIGURE 22(a). COMPOSITE MODIFICATION**

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EA 956 AAS  
LAM/PWT

## Chris Provencal

**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** October 14, 2009 1:05 AM  
**To:** 'Chris Provencal'  
**Cc:** 'Dan Stow'  
**Subject:** RE: Pod deviation # 1278

Chris,

I agree with this substitution for exactly the reasons you have outlined below.  
The only purpose of the resin in this case is to provide something hard to clamp up on.  
I would go ahead and finish the pod now.

Regards,  
David

---

**From:** Chris Provencal [mailto:cprovencal@dartaero.com]  
**Sent:** Tuesday, October 13, 2009 2:31 PM  
**To:** 'David Shepherd'  
**Cc:** 'Dan Stow'  
**Subject:** Pod deviation # 1278

David,

RE: D350-600 spacepod:

They need to drill the door to attach the hinges, as shown in Figure 22a of IIN-D350-600 (attached). They are out of Hysol EA934NA; ETA is end of October for more. Russ does have some EA956, which is called up in QSI 037 for laminating/potting. In this application, there is no insert being potted, the resin is simply being drilled.

Comparing the resins EA956 / EA934:

Tensile strength: 5,800 psi / 5,800 psi  
Compressive: 12,000 psi / 9,500 psi  
Hardness (Shore D): 85 / 85  
Bond strength: 2,300 psi / 3,100 psi (how well it bonds to aluminum test sample).

The EA956 appears to be equal to EA934, except it is weaker in bond strength. So it's obviously not as good a substitute for holding inserts, however in this case it simply needs to withstand the bearing of the bolt through the hole. Based on the compressive/hardness values it seems to be up to the task.

The pod is for stock, so it can wait until November unless there's an order.

Sincerely,  
**Christopher Provencal**  
**DART** Aerospace Ltd.

[cprovencal@dartaero.com](mailto:cprovencal@dartaero.com)  
Tel: (613) 632 5200  
Fax: (613) 632 9311

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Checked by AVG - [www.avg.com](http://www.avg.com)  
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